

Work Order ID 55707

January 28, 2010 10:41:59 AM



Page 1

Item ID: D3943-051

Accept



Setup Start



Revision ID:

Item Name: Handle Assembly

Stop



Start Date: 1/29/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/2010 Req'd Qty: 6.00



Customer:

Reference:



Approvals: Process Plan: mf

Date: 10-1-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3943

B

100

Weld per dwg. A/R Steel rod Batch: M104350 0.00



Large Fab

Memo

0.00

EL

10-2-17

(6)

Large Fab

Assemble with handle as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/22

(6)

Quality Control

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

(6)

BE 10/02/22

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3943-051

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Start Date: 1/29/2010 Start Qty: 6.00

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

0.00

Powder Cont M113544

Memo

0.00

1- MASK THREADS PRIOR TO PAINTING AS PER DWG

Start time 3:25pm

Temp 320°F

Fin time 3:55pm

X 6

φ

2- SPRAY PAINT YELLOW AS PER DWG
A/R BATCH:

140



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

*QC3
Feb 10.03.09*

BF 10-3-9

Q. φ

150



Packaging

Packaging

Identify as per dwg & Stock Location: *w/o*

0.00

Memo

0.00

55706

Q 10-3-15 (X6)

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Item ID: D3943-051

Accept



Setup Start



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Stop



Start Date: 1/29/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/10

10-3-14
(6)

Picklist Print

January 28, 2010 10:41:59 AM

Page 1

Work Order ID: 55707



Parent Item: D3943-051



Parent Item Name: Handle Assembly

Start Date: 1/29/2010

Required Date: 2/22/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3943-5

Manufactured

No

100

Each

3.0000

6.0000



3
B55711

Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

52979

3

3

100

Each

28.0000

12.0000



3

EL 10-2-10

D3943-7

Manufactured

No



Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48337

52278

52980

28

2

2

24

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3943-1 HANDLE

2 PL

9.75

2.00

Ø0.31 THRU

Ø0.12 THRU

D3943-7 STUD
2 PL

THREAD 1/2-20 UNC-2B
2 PL

THREAD 1/2-20 UNC-2B
THRU

VIEW A-A
A5-3
(SCALE 2X) B5-3

2 PL

9.37

A B1-3

A B1-3

D3943-5 PLATE

D3943-051 HANDLE ASSEMBLY

NOTES -051:

- 1) MATERIAL : N/A
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO POWDER COATING

RELEASED
2009-10-19

DEO ATTACHED

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. B
CHECKED		D3943	SHEET 3 OF 5
MFG APPR.		TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.10.15		

DRAWING NO. D3943	TITLE GROSS WEIGHT TOW CRANK ASSY		REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3943-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR. <i>[Signature]</i>		APPROVED <i>[Signature]</i>	DE APPR. N/A			
DATE 09.10.30	DATE 09.10.30	DATE 09/11/04		DATE 09/10/30	DATE			

SHEET 1 PARTS LIST MODIFY ITEM 43 AS SHOWN:

IS:

43	3			HX-16	SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG	HASKINS
----	---	--	--	-------	---	---------

WAS:

43	3			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG	HASKINS
----	---	--	--	-------	---	---------

RELEASED
2009-11-18
[Signature]

REASON: DRAFTING ERROR

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